



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5425-043

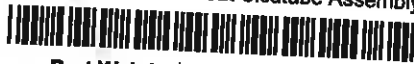
Job Sheet 198594



Part No: D5425-043

Job Qty: 1 pcs

Part Name: Float Skidtube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/31/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/30/19

Description:

Note: DWG D5425 REV.B IPP REV:A 17.11.02 NEW ISSUE DD VERF:JFS IPP REV:B 18.08.20 AS PER DWG
REV.B DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs		8/30/19	0.00	0.50	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		TF
							Skidtubes - 6		
							Skidtubes - 7		
120	HAAS 4 Axis - B4B	1 pcs		8/30/19	1.00	22.77	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 2	1 pcs		8/30/19	0.00	0.00	QC 2 - 1		cancel 19/10/25
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		



Container No: S209456



Part: D5425-043

Job No: 198594

Serial No/Batch: S209456

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/06/19

Plex 7/31/19 8:03 AM Dart.lajeunesse.marie

140 QC 8	1 pcs	8/30/19	0.00	0.00	QC 2 - 49	mmc 19/10/18
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	mmc 19/10/27
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
150 Handfinish - 1-1 Chemical-B4B	1 pcs	8/30/19	0.00	0.25	QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	OCT 30 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 -	

				B4B		
				Handfinish - 1 - 12 - B4B		
				Handfinish - 1 - 13 - B4B		
				Handfinish - 1 - 14 - B4B		
				Handfinish - 1 - 15 - B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
160 QC 7	1 pcs	8/30/19	0.00 0.00	QC 7 - 10		
				QC 7 - 13		
				QC 7 - 14		
				QC 7 - 15		
				QC 7 - 17		
				QC 7 - 18		
				QC 7 - 19		
				QC 7 - 2		
				QC 7 - 28		
				QC 7 - 3		
				QC 7 - 30		
				QC 7 - 34		
				QC 7 - 36		
				QC 7 - 37		
				QC 7 - 41		
				QC 7 - 47		
				QC 7 - 48		
				QC 7 - 51		
				QC 7 - 58		
				QC 7 - 59		
				QC 7 - 60		
				QC 7 - 9		
				QC 7 - 68		
				QC 7 - 50		
				QC 7 - 67		
				QC 7 - 40		
				QC 7 - 24		
				QC 7 - 43		
				QC 7 - 61		
				QC 7 - 81		
170 Skidtubes - Bend - 2 - B4B	1 pcs	8/30/19	0.50 1.00	Skidtubes - Bend - B4B		
180 QC 5	1 pcs	8/30/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		

7/31/2019 ,

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
190 Skidtubes - 2 - B4B	1	8/30/19	0.00	1.25		Skidtubes - 1 - B4B	
	pcs					Skidtubes - 2 - B4B	
						Skidtubes - 3 - B4B	
						Skidtubes - 4 - B4B	
						Skidtubes - 5 - B4B	
						Skidtubes - 6 - B4B	
						Skidtubes - 7 - B4B	
200 QC 5	1	8/30/19	0.00	0.00		QC 5 - 10	
	pcs					QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
210 Handfinish - 6-1- Touch Up- B4B	1	8/30/19	0.00	0.25		Handfinish - 6 - 1 - B4B	
	pcs					Handfinish - 6 - 2 - B4B	
						Handfinish - 6 - 3 - B4B	
						Handfinish - 6 - 4 - B4B	
						Handfinish - 6 - 5 - B4B	
						Handfinish - 6 - 6 - B4B	
						Handfinish - 6 - 7 - B4B	
						Handfinish - 6 - 8 - B4B	
						Handfinish - 6 - 9 - B4B	
						Handfinish - 6 - 10 - B4B	
						Handfinish - 6 - 11 - B4B	

FOT 19-11-05

DAS
NOV 05 2019 68
9-89

BEF 19-11-05

Plex 7/31/19 8:03 AM Dart.lajeunesse.marie

						Handfinish - 6 - 12 - B4B	
						Handfinish - 6 - 13 - B4B	
						Handfinish - 6 - 14 - B4B	
						Handfinish - 6 - 15 - B4B	
						Handfinish - 6 - 16 - B4B	
						Handfinish - 6 - 17 - B4B	
						Handfinish - 6 - 18 - B4B	
						Handfinish - 6 - 19 - B4B	
						Handfinish - 6 - 20 - B4B	
						Handfinish - 6 - 21 - B4B	
						Handfinish - 6 - 22 - B4B	
						QC 7 - 10	
220 QC 7	1 pcs	8/30/19	0.00	0.00		QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
						QC 7 - 28	
						QC 7 - 3	
						QC 7 - 30	
						QC 7 - 34	
						QC 7 - 36	
						QC 7 - 37	
						QC 7 - 41	
						QC 7 - 47	
						QC 7 - 48	
						QC 7 - 51	
						QC 7 - 58	
						QC 7 - 59	
						QC 7 - 60	
						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
						QC 7 - 61	
						QC 7 - 81	
230 Skidtubes - 3 - B4B	1 pcs	8/30/19	0.00	2.00		Skidtubes - 1 - B4B	
						Skidtubes - 2 - B4B	
						Skidtubes - 3 - B4B	
						Skidtubes - 4 - B4B	
						Skidtubes - 5 - B4B	
						Skidtubes - 6 - B4B	
						Skidtubes - 7 - B4B	
240 QC 5	1 pcs	8/30/19	0.00	0.00		QC 5 - 10	
						QC 5 - 12	

						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	DAS NOV 08 2019 68
						QC 5 - 9	9-89
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
250	Handfinish - 6-2- Touch Up- B4B	1 pcs	8/30/19	0.00	0.25	Handfinish - 6 - 1 - B4B	BEB 19-11/09
						Handfinish - 6 - 2 - B4B	
						Handfinish - 6 - 3 - B4B	
						Handfinish - 6 - 4 - B4B	
						Handfinish - 6 - 5 - B4B	
						Handfinish - 6 - 6 - B4B	
						Handfinish - 6 - 7 - B4B	
						Handfinish - 6 - 8 - B4B	
						Handfinish - 6 - 9 - B4B	
						Handfinish - 6 - 10 - B4B	
						Handfinish - 6 - 11 - B4B	
						Handfinish - 6 - 12 - B4B	
						Handfinish - 6 - 13 - B4B	
						Handfinish - 6 - 14 - B4B	
						Handfinish - 6 - 15 - B4B	
						Handfinish - 6 - 16 - B4B	
						Handfinish - 6 - 17 - B4B	
						Handfinish - 6 - 18 - B4B	
						Handfinish - 6 - 19 - B4B	
						Handfinish - 6 - 20 - B4B	
						Handfinish - 6 - 21 - B4B	
						Handfinish - 6 - 22 - B4B	
260	QC 7	1 pcs	8/30/19	0.00	0.00	QC 7 - 10	
						QC 7 - 13	

				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	DAS
				QC 7 - 34	81
				QC 7 - 36	9-89
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
					NOV 09 2019
270 Spray Paint - 2 - B4B	1 pcs	8/30/19	0.00 1.00	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
280 QC 14	1 pcs	8/30/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
290 Handfinish - 4-1-Assembly-B4B	1 pcs	8/30/19	0.00 0.25	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 -	

Plex 7/31/19 8:03 AM Dart.lajeunesse.marie

				B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
300 QC 5	1 pcs	8/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
310 Packaging 3-1 - Stock - B4B	1 pcs	8/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	

DAS
NOV 13 2019 68
9-89

320 QC 21 - SA	1	8/30/19	0.00	0.00	Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					QC 21 - SA - 21	045
					QC 21 - SA - 70	21
					QC 21 - SA - 53	8-80

NOV 14 2019

Part Op 110 - 1-Cut tube to finished length as per Dwg. 2-Deburr ends as per Dwg.
 Descriptions: 120 - 1-Machine as per Dwg. and Folio FB536 DWG REV: B FOLIO REV: AA 2-Deburr as per Dwg.
 130 - (QC2- Inspect parts off machine FAI/FAIB)
 140 - (QC8- Inspect parts - second check)
 150 - 1-Scrub inside of tube with medium scotchbright.
 160 - (QC7-Inspect Chemical Conversion Coat)
 170 - 1-Bend Aft end of tube as per Dwg. and Folio . Insert Bending mandrel DT 10328 at 20.0" from aft end. Use buggy A,B,C. to stabilize tube. HEIGHT 2-Bend Forward end of tube as per Dwg. and Folio . Insert Bending mandrel DT 10328 at 12.0" from fwd end. Use buggy A,B,C To stabilize tube. HEIGHT 3-Record dimensions on work order.
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - 1-Drill remaining holes of DETAIL M, N, P. USING DT10340 A,B,C,D 2-Open holes to finished size as per Dwg. 3-Deburr holes per QSI002 section 4.2.3 and blow out all chips from inside of tube.
 200 - (QC5- Inspect part completeness to step on W/O)
 210 - Handfinish Touch up alodine
 220 - (QC7-Inspect Chemical Conversion Coat)
 230 - 1-Wet install crossbolt spacers of Section G-G. Swage to 0.437 as per Dwg. PRIMER B Start Time: Finish Time: ***CURE TIME 6HRS. BEFORE PROCEEDING TO NEXT STEP*** 2-Swage crossbolt spacers of Section F-F to 0.313 as per Dwg. 3-Trim / Grind flush, deburr. 4-Identify per QSI 044 6.1
 240 - (QC5- Inspect part completeness to step on W/O)
 250 - (Touch up alodine) ***DO NOT SUBMERGE TUBE IN DEOXODIZER***
 260 - (QC7-Inspect Chemical Conversion Coat)
 270 - (Spray Paint / NDT Room) ***PLUG ALL CROSSBOLT SPACER HOLES PRIOR TO PRIME AND PAINT*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 5200299 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: 5213125
 280 - (QC14- Inspect Spray Paint)
 290 - (Assemble as per dwg) 1-Install FWD and AFT cap seal with sikaflex-241 / 291 B5200625 Exp: 20107
 Start time: 12:30 PM Finish time: 12:30 AM 2-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/R LPS Procyon B M133690
 300 - (QC5- Inspect part completeness to step on W/O)
 310 - (Identify as per dwg & Stock Location:)
 320 - (QC21- Final Inspection - Work Order Release)

Job BOM

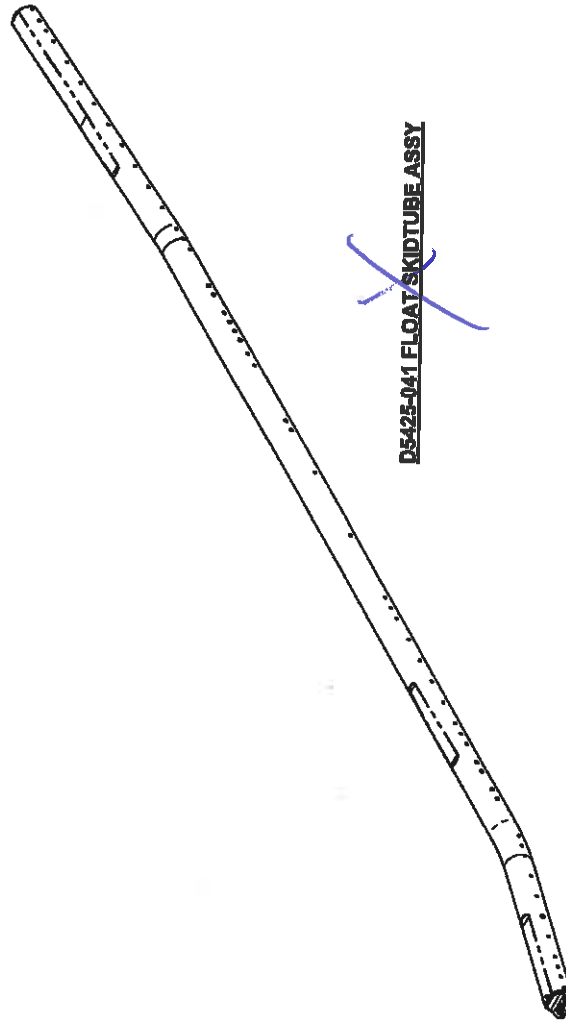
Part / Item	Component Name	Quantity	Operation	Container
D6028-195	Crosstube Material, 7075-T73/T73511	1 pcs (1 ea)	110-Skidtubes - 1	5187596
D5518-1	Crossbolt Spacer	18 pcs (18 ea)	230-Skidtubes - 3 - B4B	5148264
D5512-1	Crossbolt Spacer	12 pcs (12 ea)	230-Skidtubes - 3 - B4B	5029777
AN3C5A	Bolt	6 Ea (6 ea)	290-Handfinish - 4-1-Assembly-B4B	5123445
D3672-1	Washer, Phenolic	6 pcs (6 ea)	290-Handfinish - 4-1-Assembly-B4B	5164008
D5483-041	Tow Cap Assembly	1 pcs (1 ea)	290-Handfinish - 4-1-Assembly-B4B	5199399
D5484-041	Aft Cap Assembly	1 pcs (1 ea)	290-Handfinish - 4-1-Assembly-B4B	5228639
NAS1149C0332R	Washer (AN960C10L)	6 Ea (6 ea)	290-Handfinish - 4-1-Assembly-B4B	5218154

M. U. 012898

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D6028-195	1	5	0
230-Skidtubes - 3 - B4B	D5512-1	12	44	0
	D5518-1	18	126	0
290-Handfinish - 4-1-Assembly-B4B	AN3C5A	6	765	0
	D3672-1	6	1,581	0
	D5483-041	1	20	0
	D5484-041	1	7	0
	NAS1149C0332R	6	3,684	0
Part Specifications				
Specifications could not be found.				

Plex 7/31/19 8:03 AM Dart.lajeunesse.marie

QTY	PIN	DESCRIPTION
X	D5425-041	FLOAT SKIDTUBE ASSY
6	D5672-1	WASHER
1	D5425-1	FLOAT SKIDTUBE
1	D5483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5612-1	CROSSBOLT SPACER
27	D5618-1	CROSSBOLT SPACER
6	AN3C5A	BOLT
6	NAS1148C0332R	WASHER



D5425-041 FLOAT SKIDTUBE ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 198594 MWS
19-0731

RELEASED

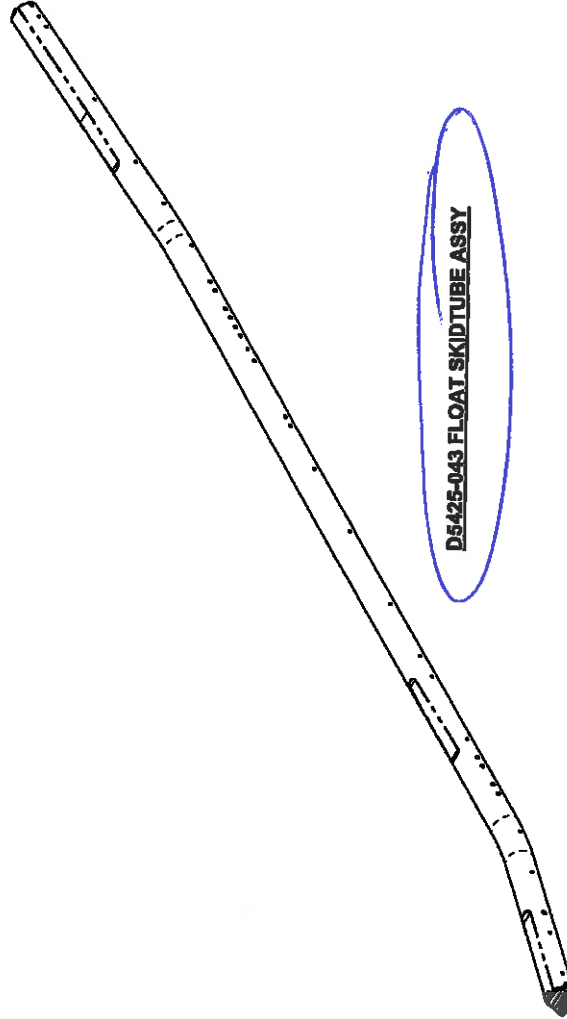
2018 AUG 16
ECN 18-796

B		CHANGE DATE LINE TO IMPROVE OFF-AXIS SWAGING IN SHEET 1 OF 10 (REV. 18-07-19). PICTORIAL UPDATE DUE TO CHANGES IN D5425-1		NO	18.02.05
A		NEW ISSUE		NO	17.07.19
REV.		DESCRIPTION		DATE	
DESIGN	NO	DART AEROSPACE USA, INC.		REV. B	
DRAWN	NO	ELMERE, OR		SHEET 1 OF 10	
CHECKED	ZF	DRAWING NO.		D5425	
MFG. APPR.	DD	TITLE		412 FLOAT SKIDTUBE	
APPROVED	NO	DATE		18.02.05	
DE APPR.	DS-1	SCALE		NTS	

APPROVED

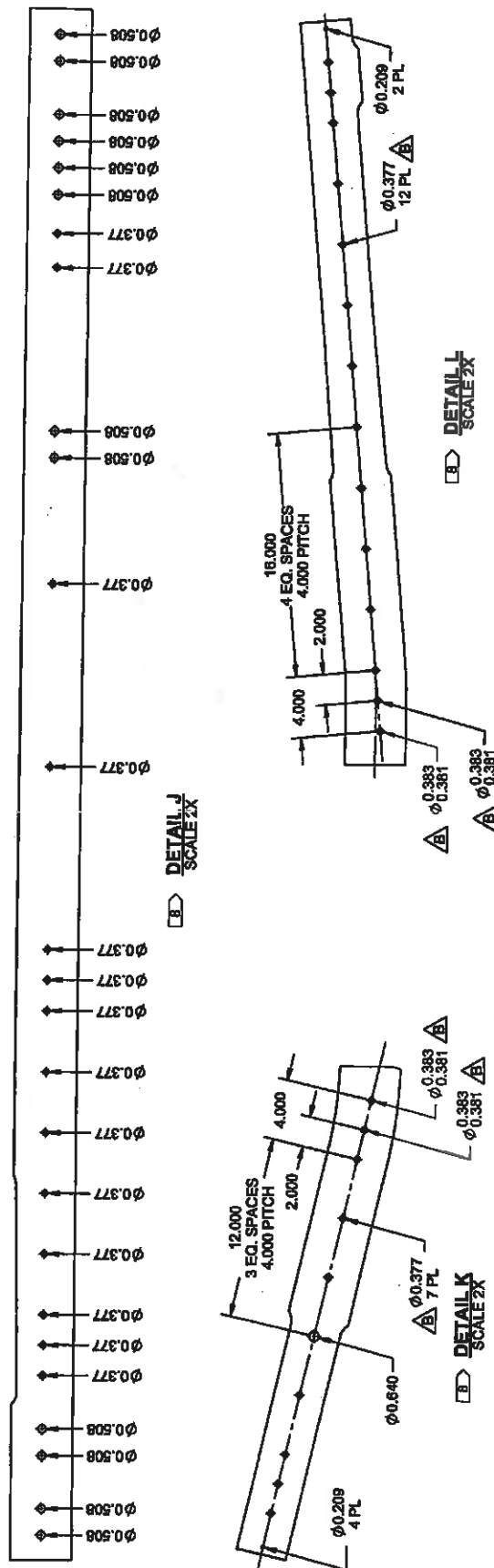
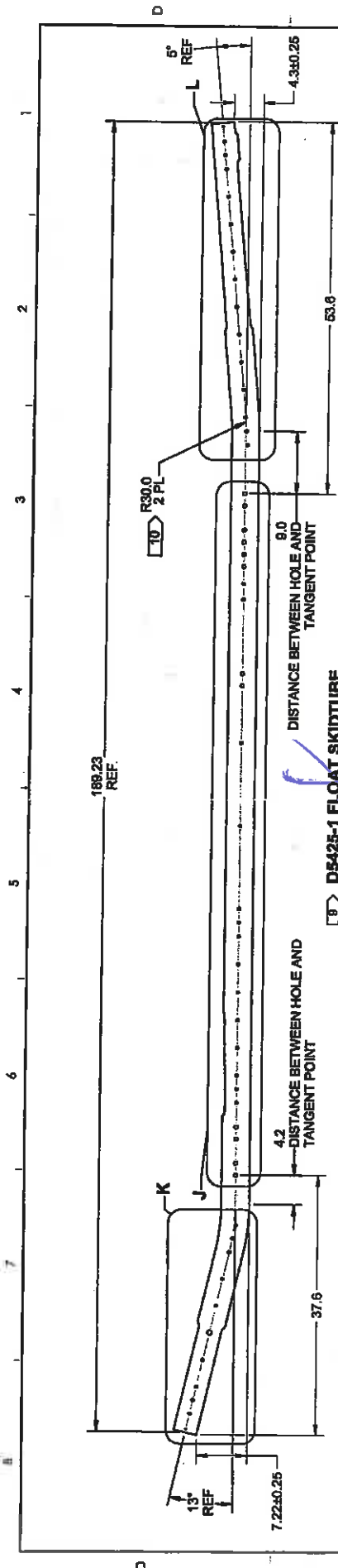
COPYRIGHT © 2017 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE
DART TO BE USED FOR THE PURPOSES OF THE CONTRACT ONLY. NO OTHER REPRODUCTION OR DISSEMINATION IS PERMITTED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.

QTY	PIN	DESCRIPTION
443		
X	D5425-043	FLOAT SKIDTUBE ASSY
6	D3672-1	WASHER
1	D6425-3	FLOAT SKIDTUBE (DART TRIBAG)
1	D6483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D6512-1	CROSSBOLT SPACER
18	D6518-1	CROSSBOLT SPACER
6	AN3CSA	BOLT
6	NAS1148C0332R	WASHER



RELEASED
2018 AUG 16 *qp*

DESIGN		NO	DART AEROSPACE USA, INC.	
DRAWN	NO		EUGENE, OR	
CHECKED	ZF		DRAWING NO.	D5425
MFG. APPR.	DD		REV. B	SHEET 3 OF 10
APPROVED	NO		TITLE	412 FLOAT SKIDTUBE
DE APPR.	D5425		SCALE	NTS
DATE	18.02.05		COPYRIGHT © 2017 BY DART AEROSPACE USA, INC.	
ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.				



NOTES:

1) MATERIAL: MAKE FROM D5425-1 DRILL

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES / MILLIMETERS

6) BREAK SHARP EDGES: 0.005 TO 0.010 IN UNITS; INCHES UNLESS OTHERWISE NOTED

8) IDENTIFICATION: NONE

7) WEIGHT: 52.57 lbs

8) ALL CENTERLINE HOLES THRU, BOTH:
9) MAXIMUM TWIST ALLOWANCE? BETWEEN

10) MAXIMUM 5% CRUSHING PER QSI 038

1

—

☉☉

.

100

RELEASED

2018 AUG 16 4

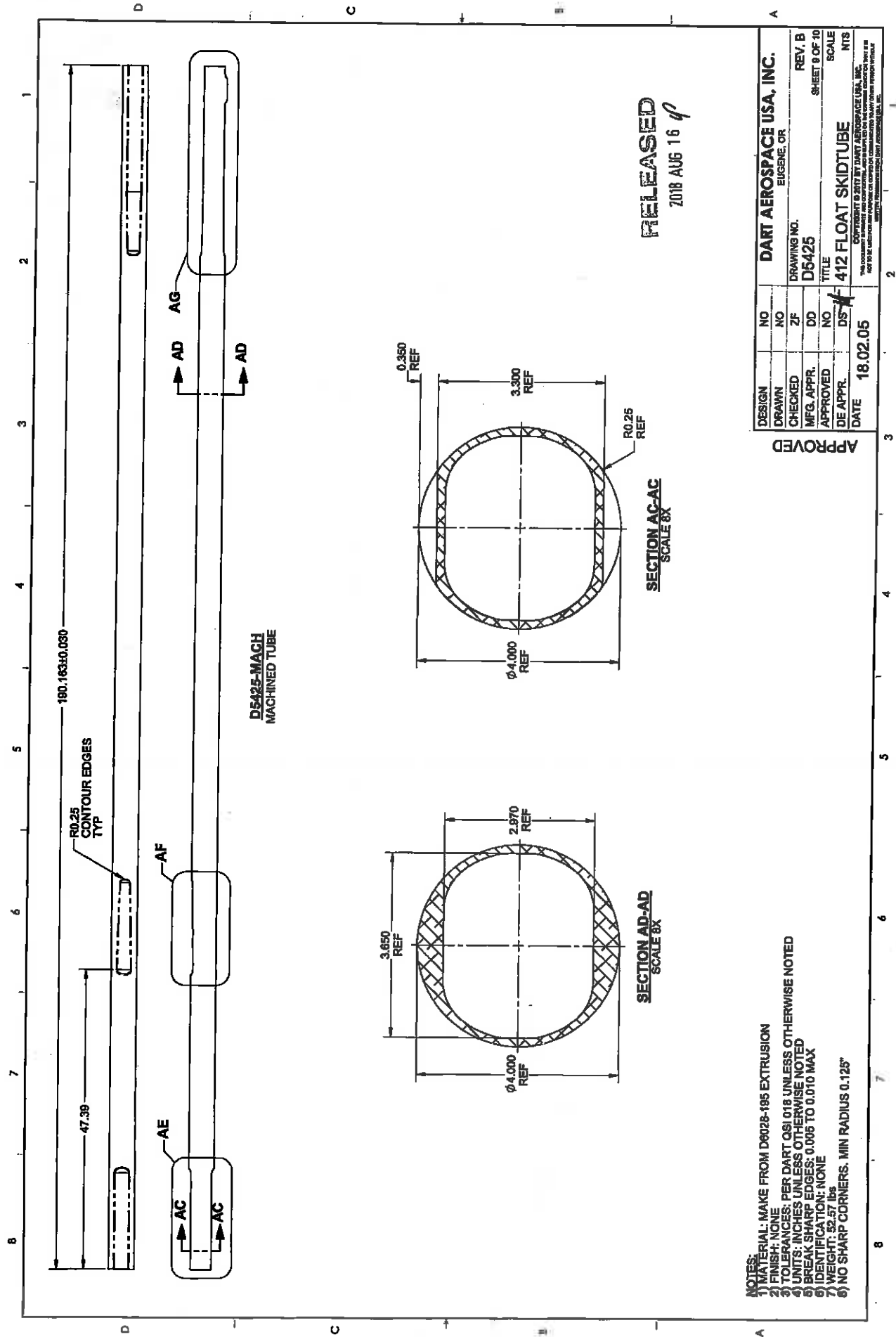
APPROVED

DESIGN	NO	DART AEROSPACE USA, INC. EUGENE, OR DRAWING NO. D5425 REV. B SHEET 5 OF 10 SCALE NTS 412 FLOAT SKIDTUBE
DRAWN	NO	
CHECKED	ZF	
MFG. APPR.	DD	
APPROVED	NO	
DE APPR.	DA	DATE
		18.02.05

Copyright © 2017 by DART Aerospace USA, Inc.

IT'S THE ONLY WAY TO GET IT RIGHT.

1



RELEASED
2018 AUG 16 4

NOTES:				DART AEROSPACE USA, INC.			
1) MATERIAL: MAKE FROM D802B-195 EXTRUSION				DESIGN	NO	NO	NO
2) FINISH: NONE				DRAWN	NO	NO	NO
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED				CHECKED	NO	NO	NO
4) UNITS: INCHES UNLESS OTHERWISE NOTED				MFG. APPR.	DD	DD	DD
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX				APPROVED	NO	NO	NO
6) IDENTIFICATION: NONE				DATE	18.02.05	18.02.05	18.02.05
7) WEIGHT: 52.57 lbs				APPROVED			
8) NO SHARP CORNERS. MIN RADIUS 0.125"				DART AEROSPACE USA, INC.			
				EUGENE, OR			
				DRAWING NO. D5425			
				REV. B			
				SHEET 9 OF 10			
				TITLE 412 FLOAT SKIDTUBE			
				SCALE NTS			
				COPYRIGHT © 2017 BY DART AEROSPACE USA, INC.			
				THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE FOR REUSE WITHOUT RESTRICTION. ANY REUSE OF THIS DOCUMENT IS AT THE USER'S RISK. NO WARRANTY IS MADE BY DART AEROSPACE USA, INC.			

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS				QTY Affected :		Disposition		MRB (QS1042)	
Job: _____	Rework ☐ ☐ ☐	Skid-tube Machining ☐ ☐ ☐	Cross tube ☐ ☐ ☐	Eng. (Non-AW) ☐ ☐ ☐	Engineering ☐ ☐ ☐	Water Jet ☐ ☐ ☐	Supplier ☐ ☐ ☐	Quality ☐ ☐ ☐	Completed By	Lead hand / Supervisor	QC / QA Coordinator
Part No. _____	Scrap ☐ ☐ ☐	Large Fab ☐ ☐ ☐	Small Fab ☐ ☐ ☐	Prod. Eng. Coord. ☐ ☐ ☐	Rec/Store/Packaging ☐ ☐ ☐						
Date: _____	Use-as-is ☐ ☐ ☐										
Description Work Order Deviation											
Other/Details:											
Root Cause											
Operator ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Manufacturing Process ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Equip/Tooling ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Handling/Preservation ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Material ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Product Improvement ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Process Improvement ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Human Factors ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Pressure/Forced ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Bending ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Crushing ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Cracks ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Marks/Chatter ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Mislabeled ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Contamination ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Misaligned/off center ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
BOM/Route ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Broken/Damage/Defect ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Drill Holes ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Fit/Function ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Power Loss/Surge ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Folio/Program ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Grain Direction ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Weld ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Wrong Stock Pulled ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Out of Sequence ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Off-set/Set-up ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Positioned Wrong ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Outside Tolerance ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Drawing ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Finish ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Part Lost/Missing ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											
Misread ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐											

DART AEROSPACE LTD		Work Order: 198594
Description: float skid tube assembly		Part Number: D5425-043
Inspection Dwg: D5425-3 Rev: B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
C. 500	+/- .010	.490				
2.790	+/- .010	2.790			dist ind	
10.790	+/- .010	10.790			rc	
14.790	+/- .010	14.790			tape	
43.120	+/- .010	43.120				
44.870	+/- .010	44.870				
48.37	+/- .010	48.37				
60.37	+/- .010	60.37				
64.37	+/- .010	64.37				
74.37	+/- .010	74.37				
123.328	+/- .010	123.328				
125.87	+/- .010	125.87				
129.37	+/- .010	129.37				
131.12	+/- .010	131.12				
134.62	+/- .010	134.62				
136.37	+/- .010	136.37				
C. 500	+/- .010	.490				
2.690	+/- .010	2.690			dist ind	
4.69	+/- .010	4.690			"	
18.69	+/- .010	18.690			"	
15.24	+/- .030	15.24			"	
R 1.0	+/- .100	1.0			tape	
0.350	+0.000 / - .020	.335			RG	
0.350	+0.000 / - .020	.345			dist ind	
R 1.0	+/- .100	1.0			"	
13.71	+/- .030	13.71			RL	
0.152	+/- .015	.154			tape	
0.250	+/- .015	.236			dist ind	
9.35	+/- .030	9.35			"	
0.350	+0.000 / - .020	.335			tape	
20.00	+/- .030	20.00			dist ind	
0.250	+/- .015	.236			tape	
					dist ind	

Measured by: <i>mmc</i>	Checked by: <i>mmf</i>	QC Inspector:
Date: 19/10/25	Date: 19/10/27	Date:

Engineering Approval: (if necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

DART AEROSPACE LTD

Work Order:

Description:

Part Number:

Inspection Dwg:

Rev:

Page 1 of 1

[illegible]**Measured by:**

2nd

Date: _____

14/10/25

Checked by:

9

Date:

19/10/27

QC Inspector:

Date:

Engineering Approval:
(If necessary)

Date:

Rev

Date _____

Change

14.07.31

New Issue

Revised by

KJ

Approved